

Vload



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2571

Job Sheet 185372



Part No: D2571

Job Qty: 12 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Due Date: 11/9/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		11/9/18	0.00	0.00	Start Up Machining		UHB 18/12/11
100	CNC Vertical Machining	12 pcs		11/9/18	0.57	19.35	HAAS 1		SBZ 18/01/05
110	Mill Conv	12 pcs		11/9/18	0.00	1.85	Mill Conv 1		SBZ 19/01/05
120	QC	12 pcs		11/9/18	0.00	0.00	QC2		SBZ 18/01/05
130	QC	12 pcs		11/9/18	0.00	0.00	QC8		SBZ 18/01/05
140	HandFinish	12 pcs		11/9/18	0.00	0.40	HandFinish1		DR 19/01/07
150	Powdercoat	12 pcs		11/9/18	0.00	0.48	Powdercoat1		BR 19-01-05
160	QC	12 pcs		11/9/18	0.00	0.00	QC3		JAN 09 2019 68
170	Packaging	12 pcs		11/9/18	0.00	0.00	Packaging3		SBZ 11/12/199-89
180	QC21-SA	12 Ea		11/9/18	0.00	0.00	QC21		JAN 14 2019

Part Op 100 - Program Batch No. 5136953 Double check by: me 1-Machine Step No 1 per Folio FA051 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect

110 - Machine keyway as per dwg D2571 & D2572

120 - Inspect on CMM as per folio CMM022.

150 - START TIME: 1:05 FINISH TIME: 2:05 O.V.T. 320° M 138951

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	12 Ea (1 ea)	90-Start up Operation	<u>5133600</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	12	27	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@artaero.com
www.dartaerospace.com

Container No: S136953



Part: D2571

Job No: 185372

Serial No/Batch: S136953

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/11/18

3	Saddle, Fwd Outboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495
4	Saddle, Fwd Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745
5	Saddle, Fwd Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Outboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Outboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020	2.020

10/25/2018

[Dart Hawkesbury] Job Sheet - White, Jesse

		- 0.000	2.000
36	Saddle, Fwd Outboard	+ 0.020	0.043
	0.023Inches	- 0.000	0.023

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185372

DART AEROSPACE LTD		Work Order: 182654	
Description: Saddle, Fwd Outboard		Part Number: D2571	
Inspection Dwg: D2571 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.502	.502	.501	.495		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.499	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.567	.565	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.132	.130	.128		
Q	0.115	0.135		.124	.124	.125	.124		
R	0.240	0.260		.253	.253	.253	.252		
S	0.115	0.135		.123	.128	.131	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		.243	.243	.243	.243		
W	0.115	0.135		.123	.122	.124	.123		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.625	.625		
AC	0.053	0.073		.060	.055	.055	.053		
AD	0.240	0.260		.254	.254	.254	.254		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.125	.125	.128		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.245	.252	.253	.245		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	DAS
Date:	57 18/12/24

Audited by:	
Date:	19/01/05

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 185 372
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5 1	6 2	7 3	8 4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.50	3.500		
D	1.745	1.755		1.750	1.7500	1.750	1.750		
E	7.990	8.010		8.000	8.008	7.997	8.006		
F	0.490	0.510		.501	.506	.496	.504		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.500	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.568	.566	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.127	.130	.125	.130		
Q	0.115	0.135		.124	.124	.124	.125		
R	0.240	0.260		.253	.253	.252	.252		
S	0.115	0.135		.124	.121	.121	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.958		
V	0.230	0.250		.243	.243	.243	.242		
W	0.115	0.135		.122	.123	.124	.124		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.624	.625		
AC	0.053	0.073		.057	.055	.055	.055		
AD	0.240	0.260		.253	.253	.253	.252		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.125	.125	.128		
AG	0.240	0.280		.255	.255	.253	.255		
AH	0.240	0.260		.246	.245	.243	.247		
AI	2.000	2.020		2.000	2.00	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	DAS
Date:	57 18/12/24
	9-89

Audited by:	amk
Date:	19/01/05

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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DART AEROSPACE LTD	Work Order: 185372
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	91	102	113	124		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	8.000	7.998		
F	0.490	0.510		.503	.508	.501	.501		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.498	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.565	.567	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.130	.130	.130		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.122	.130	.128	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.243	.241	.241	.242		
W	0.115	0.135		.123	.126	.122	.123		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.055	.055	.057	.055		
AD	0.240	0.260		.252	.250	.251	.252		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.122	.125	.125	.125		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.243	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

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